

Date: Monday, 14/11/2005 3:41:46 PM  
 User: Alba Panzuto

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, RH, 206
Job Number	: 24499		
Estimate Number	: 10523		
P.O. Number	: N/A	Part Number	: D26652
This Issue	: 14/11/2005 S.O. No. : N/A	Drawing Number	: D2665 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 30/11/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	4 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875 <i>B 24891</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Program batch number
- 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet
- 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet
- 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet
- 5- Deburr *En 06/01/12*

*En 06/01/12**4*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*En 06/01/13*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*En 06/01/13 4*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SL 06.01.13 4*

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*SAD 06.01.14 4*

24  
 2  
 3

Date: Monday, 14/11/2005 3:41:46 PM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 24499

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

md 06 01 16 4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C206/01/17 4

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 363

C206/01/17 (4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505 06/01/18 (4) SP 06/01/18 (4)

Job Completion



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:21 pm

Work Order No	: 0024499	Department Code:	
Project Name	: D2665-2	Burden Flags	: NNNNNNNN
Project For	: WK543	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2665-2	Invoice Number	:
Description	: Saddle, RH, Fwd,Aft, Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-08-05		
Est Finish Date	: 10-30-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

MIS 8/15  
a  
11-15

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24499
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2665-2
<b>Inspection Dwg:</b> D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	0.120	0.117	0.117		
B	0.100	0.140		.120	0.119	0.118	0.117		
C	0.100	0.140		.123	0.117	0.116	0.120		
D	0.210	0.230		.219	0.219	0.217	0.219		
E	1.245	1.255		1.248	1.249	1.247	1.247		
F	1.245	1.255		1.251	1.249	1.247	1.247		
G	5.990	6.010		6.002	6.004	6.003	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.679	1.678	1.680		
J	2.495	2.505		2.498	2.499	2.499	2.499		
K	0.257	0.262	DT8683	.258	0.259	0.259	0.259		
L	0.312	0.317	DT8686	.314	0.314	0.314	0.314		
M	0.235	0.240		0.237	0.239	0.239	0.238		
N	0.100	0.140		.118	0.119	0.119	0.120		
O	0.540	0.560		.546	0.551	0.551	0.546		
P	0.490	0.510		.501	0.494	0.497	0.497		
Q	3.609	3.619		3.612	3.611	3.612	3.612		
R	2.470	2.510		2.491	2.497	2.497	2.497		
S	0.240	0.270		.249	0.248	0.250	0.247		
T	0.100	0.180		.137	0.137	0.137	0.137		
U	0.313	0.318	DT8686	0.318	0.138	0.138	0.138		
V	1.125	1.145		1.137	1.135	1.136	1.137		
W	1.565	1.585		1.576	1.576	1.574	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RG / EP
Date:	06.01.11 06/01/12

Audited by:	SD
Date:	06.01.14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

5/43

(8)

DART AEROSPACE LTD.	Work Order :	24499
Description: 206 Saddle, Outboard, Right Side	Part Number:	D2665-2
Drawing: D2665 Rev B	Qty:	4




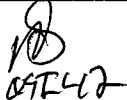

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>CF</i>	05.10.12	4
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: <i>B24896</i>	BG	06.01.10	4
3	HAAS	Program batch number.	BG	06.01.10	4
4	QC	Inspect part number and batch number are programmed correctly.	BG	06.01.10	4
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed on <i>      </i> by <i>      </i>			
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>En</i> BG	06.01.12	4
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>En</i> BG	06.01.12	4
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>En</i> BG	06.01.12	4 PTO
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>En</i>	06/01/13	4
12	METAL	Deburr	<i>En</i>	06/01/12	4
13	HAAS	Inspect Level 1	<i>En</i>	06/01/13	4
14	QC	Inspect Level 8			
15	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>SAD</i>	06/01/14	9
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3			
17	QC	Inspect Level 3	<i>CL</i>	06/01/17	4
18	STORES	Pack in foam, identify and stock. <i>LUC 363</i>	<i>CL</i>	06/01/17	4
19	EXPEDITING	Close Work Order Job Cost / Part			

Rev.	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	<i>h.</i>

RELEASED

DEC 18 2000

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.01.11	10	Chamber o/s on top surface		Tool offset changed 1QC destroyed + replaced	 06.01.11	 06.01.11	 06.01.11	 06.01.11

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/01/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 11, 2005  
07:41 am

Work Order No	:	0024499	Department Code:	
Project Name	:	D2665-2	Burden Flags	: NNNNNNNN
Project For	:	WK543	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2665-2	Invoice Number	:
Description	:	Saddle, RH, Fwd,Aft, Out	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	10-08-05		
Est Finish Date	:	10-30-05	Est Mark Up	: 0.000%
Act Finish Date	:		Actual Mark Up	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
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Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00